

Date: Thursday, 2/23/2006 10:24:08 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET	
Job Number	: 25924		Part Number	: D3046041	
Estimate Number	: 10364		Drawing Number	: D3046 REV. A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/23/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 3/2/2006	
Previous Run	: 25383		Qty:	3 Um: Each	
Written By	: SEE COMMENT BELOW				
Checked & Approved By	: JH 06.02.23				
Comment	: Est: A 01.08.27 New issue SM/EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D30461	Lug Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) LUG BRACKET	
		Qty Part Number Description Batch	
	1 D3046-1	Lug Bracket	B40715
			SB 06/03/05
2.0	D30463	Lug Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) LUG BRACKET	
		Pick:	
		Qty Part Number Description Batch	
	1 D3046-3 ( Bell P/N: 206-052-106-1)	Lug Bracket	N/A
		Return Authorization #	R426/R455 (x1)
		Bell original batch#	③ B4071 ① B26224
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1- Tranfer drill holes from D3046-3 into D3046-1 as per Dwg D3046	
		2- Counter sink inside holes of D3046-1 as per Dwg D3046	
		3- Deburr	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/20 \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3046041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DC 06/03/17 (4)

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

m 06/03/17 (4)

7.0 MS20426AD57 Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 30.0000 Each(s)

Rivet

Qty Part Number Description Batch  
10 MS20426AD5-7 Rivet 13876

W 06/03/14

SB 06/03/17 (4)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DC 06/03/17 (4)

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DC 06/03/17 (4)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

m 06/03/17 (4)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:   

C 06/03/17 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3046041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL  
Inspection Level 21

100 06/03/17

Job Completion



u 06/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

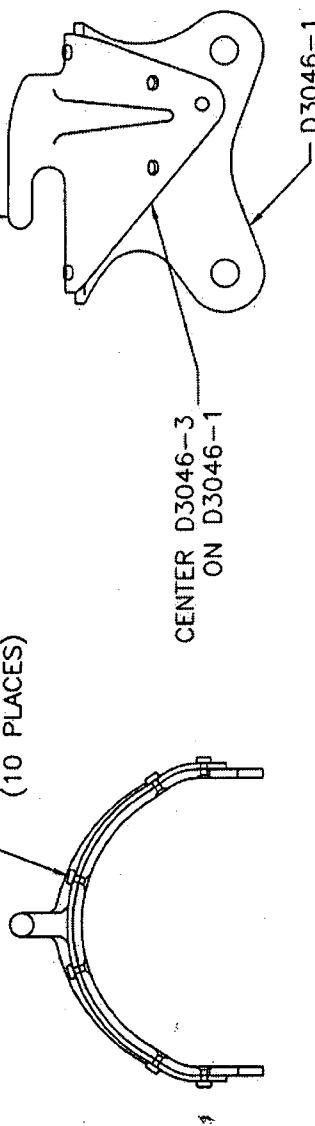
NOTE: Date & initial all entries

**DART**COPY ISSUED  
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3046	SHEET 1 OF 2
01.08.23		LUG BRACKET	SCALE 1:2
A	01.08.23	NEW ISSUE	

D3046-3  
(BELL P/N 206-052-106-1)

TRANSFER DRILL  $\varnothing$ 0.156 HOLES  
FROM D3046-3 TO D3046-1.  
C'SINK  $\varnothing$ 0.286 x 100.  
D3046-1 INSIDE BORE.  
ASSEMBLE USING MS20426AD5-7  
RIVETS.  
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

NOTES:  
1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
2) POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.  
RE-POWDER AFTER ASSEMBLY.  
3) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 25924

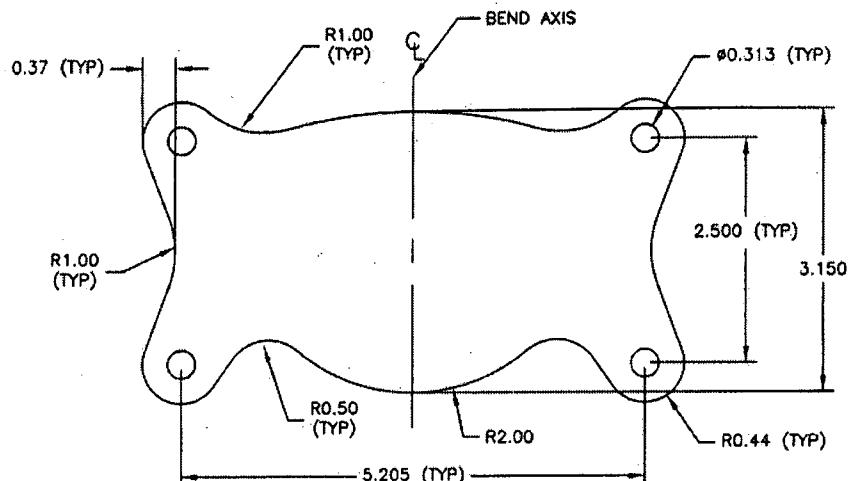
RELEASED  
01.08.27

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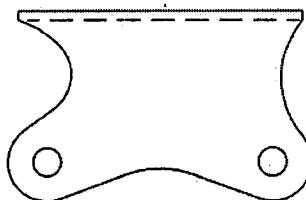
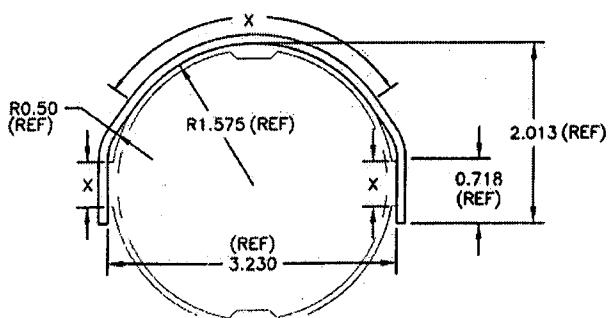
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	01.08.23	D3046	SHEET 2 OF 2



D3046-11 FLAT PATTERN  
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1  
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE  
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

SHOP COPY  
RETURN TO  
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WITHOUT NOTICE

WORK ORDER  
NO. 25924

GENERAL NOTES  
MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

RELEASED  
01.08.23